



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3411
Job Sheet 190715



Part No: 646.3411

Job Qty: 12 pcs

Part Name: RH Wiper Deflector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/13/19

Job Tracking No:

Due Date: 3/22/19 *March 29*

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV N/C SHEET 1 IPP REV:A NEW ISSUE 13/02/21 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs		3/22/19	0.00	2.00	Bandsaw - 1		<i>mm</i>
110	HAAS 4 Axis - B4B	12 pcs		3/22/19	0.00	20.41	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		<i>mm</i>
120	QC 2	12 pcs		3/22/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		



Container No: S161506



Part: 646.3411

Job No: 190715

Serial No/Batch: S161506

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/21/19

Plex 2/13/19 3:12 PM Dart.lajeunesse.marie



Container No: S161506



Part: 646.3411

Job No: 190715

Serial No/Batch: S161506

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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Date: 03/12/19

130	QC 8	12 pcs	3/22/19	0.00	0.00	QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	DAS
						QC 2 - 64	64
						QC 8 - 12	9-89
						QC 8 - 14	ML 19/08/12
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
140	Outsource - 4 - Anodize	12 pcs	3/22/19			ATG001-VC	8
150	Packaging 2-1 - Receive - B4B	12 pcs	3/22/19	0.00	0.00	Packaging 2 - 1 - B4B	03/14/2019 PL
						Packaging 2 - 2 - B4B	
						Packaging 2 - 3 - B4B	
						Packaging 2 - 5 - B4B	
						Packaging 2 - 4 - B4B	
						Packaging 2 - 6 - B4B	
						Packaging 2 - 7 - B4B	
						Packaging 2 - 8 - B4B	
						Packaging 2 - 9 - B4B	
						Packaging 2 - 10 - B4B	
						Packaging 2 - 11 - B4B	
						Packaging 2 - 12 - B4B	
						Packaging 2 - 13 - B4B	OP MAR 2 1 2019
						Packaging 2 - 14 - B4B	
						Packaging 2 - 15 - B4B	
						Packaging 2 - 16 - B4B	
						Packaging 2 - 17 - B4B	
						Packaging 2 - 18 - B4B	
						Packaging 2 - 19 - B4B	
						Packaging 2 - 20 - B4B	
						Packaging 2 - 21 -	

				B4B		
				Packaging 2 - 22 - B4B		
				Packaging 2 - 23 - B4B		
				Packaging 2 - 24 - B4B		
				Packaging 2 - 25 - B4B		
				Packaging 2 - 26 - B4B		
				Packaging 2 - 27 - B4B		
				Packaging 2 - 28 - B4B		
				Packaging 2 - 29 - B4B		
				Packaging 2 - 30 - B4B		
				Packaging 2 - 31 - B4B		
				Packaging 2 - 32 - B4B		
				Packaging 2 - 33 - B4B		
				Packaging 2 - 34 - B4B		
				Packaging 2 - 35 - B4B		
				Packaging 2 - 36 - B4B		
155	QC 5	12 pcs	3/22/19	0.00	0.00	QC 5 - 10
						QC 5 - 12
						QC 5 - 17
						QC 5 - 18
						QC 5 - 19
						QC 5 - 22
						QC 5 - 24
						QC 5 - 3
						QC 5 - 42
						QC 5 - 43
						QC 5 - 49
						QC 5 - 51
						QC 5 - 58
						QC 5 - 68
						QC 5 - 9
						QC 5 - 50
						QC 5 - 30
180	Packaging 3-1 - Stock - B4B	12 pcs	3/22/19	0.00	0.00	Packaging 3 - 1 - B4B
						Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 -

APR 02 2019
 DAS
 9-89

APR 03 2019
 CCK 1091

				B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAG 21
190 QC 21 - SA	12 pcs	3/22/19	0.00 0.00	QC 21 - SA - 21	9-85 APR 03 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **100** - (Bandsaw) Cut Blank at 7.125"

Descriptions: **110** - (HAAS CNC Vertical Machine) 1-Machine per folio FB151 DWG REV: _____ FOLIO REV: _____ 2-
deburr and break all sharp edges

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Issue P/O to ATG : _____ 1- Hard Anodize, Color Black and Prime as per Dwg 646.3400

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC5- Inspect part completeness to step on W/O)

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S4.000X3.000	7075-T6S Sheet 4.000" Thick X 3.000" Wide	7.1280 ft (.594 ea)	100-Bandsaw - 1	FR138252.85

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S4.000X3.000	7	31	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wiper Deflector, RH	3.950inches ± 0.010	3.960 3.940		
2	Wiper Deflector, RH	5.050inches ± 0.010	5.060 5.040		
3	Wiper Deflector, RH	70.000Degrees ± 0.500	70.500 69.500	Angle	
4	Wiper Deflector, RH	40.000Degrees ± 0.500	40.500 39.500	Angle	
5	Wiper Deflector, RH	0.500inches ± 0.010	0.510 0.490	Radius	
6	Wiper Deflector, RH	0.250inches ± 0.010	0.260 0.240		
7	Wiper Deflector, RH	1.100inches ± 0.010	1.110 1.090		
8	Wiper Deflector, RH	0.310inches ± 0.010	0.320 0.300		
9	Wiper Deflector, RH	45.000inches ± 0.500	45.500 44.500		
10	Wiper Deflector, RH	0.190inches ± 0.010	0.200 0.180	Radius	
11	Wiper Deflector, RH	6.880inches ± 0.010	6.890 6.870		
12	Wiper Deflector, RH	6.250inches ± 0.010	6.260 6.240		
13	Wiper Deflector, RH	5.740inches ± 0.010	5.750 5.730		
14	Wiper Deflector, RH	4.630inches ± 0.010	4.640 4.620		
15	Wiper Deflector, RH	0.500inches ± 0.010	0.510 0.490	Radius	
16	Wiper Deflector, RH	1.630inches ± 0.010	1.640 1.620		
17	Wiper Deflector, RH	3.000inches ± 0.010	3.010 2.990		
18	Wiper Deflector, RH	30.000Degrees ± 0.500	30.500 29.500	Angle	
19	Wiper Deflector, RH	0.190inches ± 0.010	0.200 0.180	Radius	
20	Wiper Deflector, RH	0.750inches ± 0.010	0.760 0.740		
21	Wiper Deflector, RH	2.750inches ± 0.010	2.760 2.740		
22	Wiper Deflector, RH	0 ± 0			
23	Wiper Deflector, RH	45.000Degrees ± 0.500	45.500 44.500	Angle	
24	Wiper Deflector, RH	0.380inches ± 0.010	0.390 0.370		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD	Work Order:	
Description: Wiper Deflector, RH	Part Number:	646.3411
Inspection Dwg: 646.3400 Rev: N/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.95	+/-0.010	3.945	✓		vernier	
5.05	+/-0.010	5.051	✓		high gage	
70.0°	+/-0.5°	70°	✓		Gabarit	
40.0°	+/-0.5°	40°	✓		Gabarit	
R0.50	+/-0.010	R.50 ok	✓		Gabarit	
0.25	+/-0.010	.251	✓		Vernier	
1.10	+/-0.010	1.099	✓		high gage	
0.31 x 45°	+/-0.010 x +/-0.5°	.320 x 45°	✓		Vernier	
R0.19	+/-0.010	R.190 ok	✓		Gabarit	
6.88	+/-0.010	6.877	✓		high gage	
6.25	+/-0.010	6.25	✓		high gage	
5.74	+/-0.010	5.737	✓		high gage	
4.63	+/-0.010	4.63	✓		high gage	
R0.50	+/-0.010	R.500	✓		Gabarit	
1.63	+/-0.010	1.63	✓		vernier	
3.00	+/-0.010	3.00	✓		vernier	
30.0°	+/-0.5°	30°	✓		Gabarit	
R0.19	+/-0.010	R.190 ok	✓		Gabarit	
0.75	+/-0.010	.745	✓		vernier	
2.75	+/-0.010	2.748	✓		high gage	
2.00	+/-0.010	1.999	✓		high gage	
45°	+/-0.5°	45°	✓		Gabarit	
0.38	+/-0.010	.372	✓		micrometer	

Measured by: <i>mm</i>	Audited by: <i>mm</i>	Preliminary Approval:
Date: 2019/03/01	Date: 19/03/12	Date:

Rev	Date	Change	Revised by	Approved
A	13.05.08	New Issue	KJ	<i>[Signature]</i>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042883



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042883
PO Date: 3/14/19
Due Date: 3/20/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190859	RB23003267-3B	Block -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/20/19	8 pcs	0 pcs	8 pcs	\$2.90/pcs	\$23.20
Line Item Note ** NEED BACK ASAP **											
2	190861	RB23003267-5B	Block -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/20/19	8 pcs	0 pcs	8 pcs	\$2.90/pcs	\$23.20
Line Item Note ** NEED BACK ASAP **											

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1270 Aberdeen St
Hawkesbury, ON
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PURCHASE ORDER PO042883



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	190863	RB23003267-7B	Block -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/20/19	8 pcs	0 pcs	8 pcs	\$2.90/pcs	\$23.20
Line Item Note ** NEED BACK ASAP **											
4	190865	RB23003267-9B	Block -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/20/19	8 pcs	0 pcs	8 pcs	\$2.90/pcs	\$23.20
5	190857	RB23003267-11B	Block -Issue P/O; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/20/19	8 pcs	0 pcs	8 pcs	\$2.90/pcs	\$23.20
Line Item Note ** NEED BACK ASAP **											



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PURCHASE ORDER PO042883



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	189137	RB23007615-3	#56 Drill Bit Outsource process- Anodize per QSI017 4.1.10.1) - Issue P/O to ATG; PO -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	3/20/19	10 pcs	0 pcs	10 pcs	\$2.90/pcs	\$29.00

Line Item Note ** NEED BACK ASAP **

7	189138	RB23007615-5	#52 Drill Bit Outsource process- Anodize per QSI017 4.1.10.1 - Issue P/O to ATG; PO -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	3/20/19	12 pcs	0 pcs	12 pcs	\$2.90/pcs	\$34.80
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Line Item Note ** NEED BACK ASAP **

8	189134	RB23007615-11	#12 Drill Bit Outsource process- Anodize per QSI017 4.1.10.1 - Issue P/O to ATG; PO -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	3/20/19	10 pcs	0 pcs	10 pcs	\$2.90/pcs	\$29.00
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Line Item Note ** NEED BACK ASAP **

9	190715	646.3411	RH Wiper Deflector Issue P/O to ATG : 1- Hard Anodize, Color Black and Prime as per Dwg 646.3400	Firmed	-	3/20/19	12 pcs	0 pcs	12 pcs	\$11.92/pcs	\$143.04
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Line Item Note ** NEED BACK ASAP **

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PURCHASE ORDER PO042883



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
10	187912	649.5112	RH Wiper Deflector Issue P/O to ATG : AS PER DWG 649.5100 1- Black Anodize 2- PRIME, SEE NOTE #2 Certification of Conformity is required	Firmed	-	3/20/19	4 pcs	0 pcs	4 pcs	\$17.52/pcs	\$70.08
Line Item Note ** NEED BACK ASAP **											
11	191829	D5155-043	Co-Pilot Collective Head Assembly (212/412) : Various STC's Anodize Black as per Dwg D5155 Rev. B	Firmed	-	3/20/19	2 pcs	0 pcs	2 pcs	\$2.90/pcs	\$5.80
Line Item Note ** NEED BACK ASAP **											
12	190714	646.3410	LH Wiper Deflector Issue P/O to ATG : 1- Hard Anodize, Color Black and Prime as per Dwg 646.3400	Firmed	-	3/20/19	12 pcs	0 pcs	12 pcs	\$11.92/pcs	\$143.04
Line Item Note ** NEED BACK ASAP **											
Grand Total:										\$570.76	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 917503

Date: 20-Mar-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
1 ea	Part: 649.5112 RH Wiper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24809	Rev: D PO: PO042883	Line: 10
12 ea	Part: 646.3410 LH Wiper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24811	Rev: N/C PO: PO042883	Line: 12
12 ea	Part: 646.3411 RH Wiper Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 24808	Rev: NC PO: PO042883	Line: 9
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAR 20 2019</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of Made in Canada.			

